

17/9

Dart Aerospace Ltd.

Date: Tuesday, 9/11/2007 10:54:49 AM  
User: Chantal Lavoie

# Process Sheet

Customer : <u>N/A</u>	Drawing Name : STIFFNER
Job Number : 34539	
Estimate Number : 12956	
P.O. Number : <u>N/A</u>	Part Number : D36392
This Issue : 9/11/2007	Drawing Number : D3639 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u>	Drawing Revision : U/R
Previous Run : <u>N/A</u>	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 9/18/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 12 Um: Each
Comment : Est Rev:A New Issue 07-07-20 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.2510 sf(s)/Unit Total : 3.0114 sf(s)  
2024-T3 .050 sheet  
Batch: M105646 B07-09-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3639  
Dwg Rev: A B07-09-19  
Prog Rev: A  
2-Deburr if necessary

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EP 2/08/19 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
~~Cut as per Dwg D3639~~

N/A 02-09-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 07/18/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/11/2007 10:54:49 AM  
User: Chantal Lavoie

## Process Sheet

Customer:

Drawing Name: STIFFNER

Job Number: 34539

Part Number: D36392

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3639

SD 07/09/20

(12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counters  
En 07/09/20 (12)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FE 07/09/20 (12)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

counters  
En 07/09/20 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

LE 07.10.15  
ENGINEERING  
APPROVAL  
7/10/15 SP (12x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(12)  
07/10/20

Job Completion



LE 07.10.22

POSITIVE RECALL

EFFECTIVE 07.09.11 AUTH LE  
BASED LE DATE 07.10.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

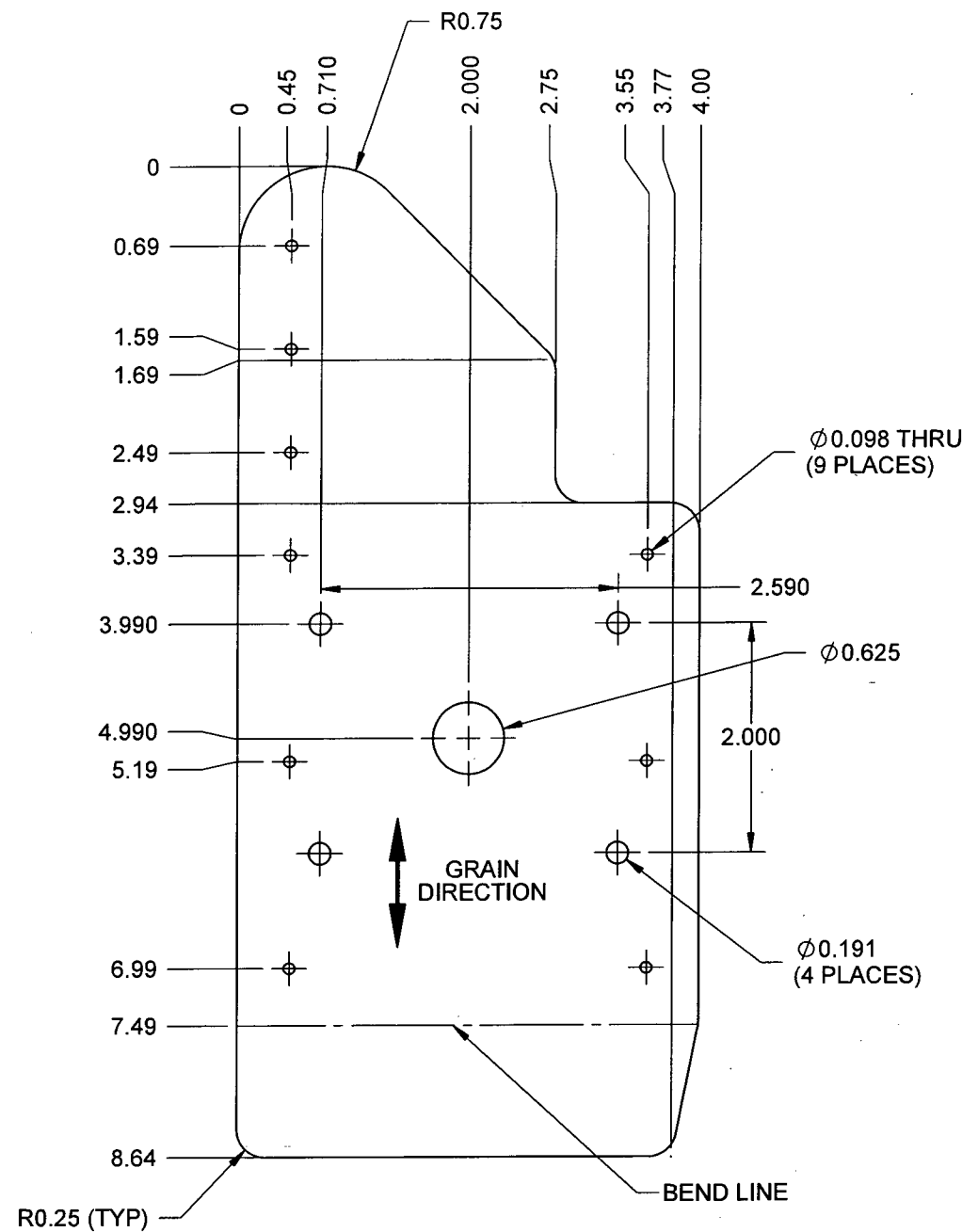
8 7 6 5 4 3 2 1

D

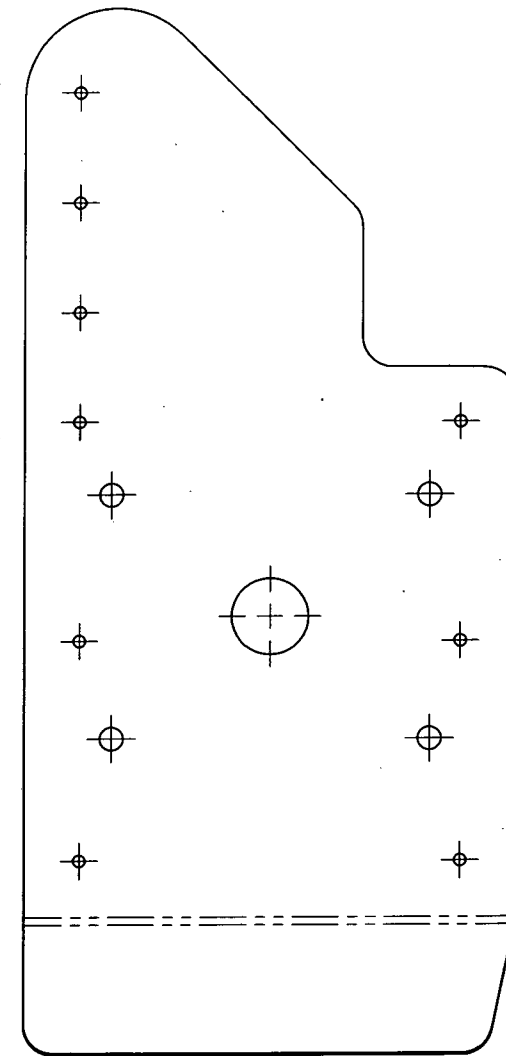
C

B

A



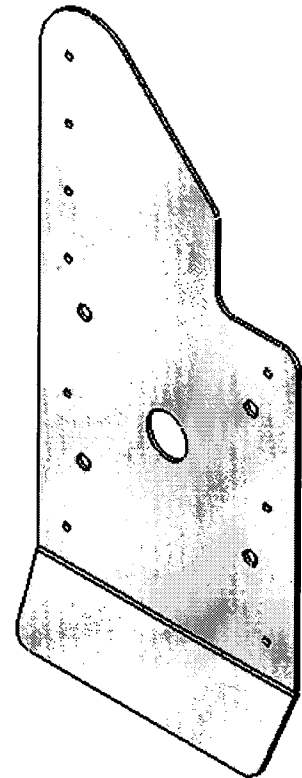
**D3639-1F FLAT PATTERN**  
**(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER**  
**(WAS GENEVA P/N G10604-3)**  
**D3639-2 OPPOSITE**  
**(WAS GENEVA P/N G10604-6)**

8.59

19° (REF)



D

C

B

A

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

**PRELIMINARY ISSUE**

07.09.07 LE

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN	LE			
CHECKED	TS	DRAWING NO.	REV. A	
MFG. APPR.	TS	D3639	SHEET 1 OF 2	
APPROVED	TS	TITLE	SCALE	
DE APPR.	TS	DOUBLER	2:3	
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

DART AEROSPACE LTD		Work Order: 34539
Description: STIFFENER		Part Number: D3639-2
Inspection Dwg: D3639 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .625	+ .008 - .001	.628	*			
Ø .191	+ .005 - .001	.195	*			
Ø .098	+ .004 - .001	.101	*			
.69	+/- .030	.69	*			
1.59	+/- .030	1.59	*			
1.69	+/- .030	1.69	*			
2.49	+/- .030	2.49	*			
2.94	+/- .030	2.94	*			
3.39	+/- .030	3.39	*			
3.990	+/- .010	3.990	*			
4.990	+/- .010	4.990	*			
5.19	+/- .030	5.19	*			
6.99	+/- .030	6.99	*			
8.64	+/- .030	8.64	*			
.45	+/- .030	.45	*			
.710	+/- .010	.710	*			
2.000	+/- .010	2.000	*			
2.75	+/- .030	2.75	*			
3.55	+/- .030	3.55	*			
4.00	+/- .030	4.00	*			
.050	+/- .010	.052	*			

Measured by: RB	Audited by: En	Prototype Approval: LE
Date: 07-09-19	Date: 07/02/19	Date: 07.09.19

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	